

Work Order ID 86618

Friday, July 06, 2012 10:12:40 AM

86618

Page 1

Item ID: D4522-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Handle Shaft Arm

Stop ***NS2***

Start Date: 7/5/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *12-08-06* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4522

B

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 1.910"

B.A 12/07/10

2 0

110

0.00

110

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB112

FOLIO REV: *44*

DWG REV: *B*

mf 12/07/13

2 0

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

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Setup Start

NS1

Revision ID:

Item Name: Handle Shaft Arm

Stop

NS2

Start Date: 7/5/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

OK 12/07/13

2 2

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

2 12-7-16

140

Identify as per dwg & Stock Location

0.00

140

Packaging

Memo

0.00

Packaging

2x

SP
12-7-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, July 06, 2012 10:12:40 AM

Page 1

Work Order ID: 86618
Parent Item: D4522-11
Parent Item Name: Handle Shaft Arm

Start Date: 7/5/2012 Required Date: 7/19/2012
Start Qty: 2.00 Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-01-04 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1:000X2.000 303 BAR 1" X 2"		Purchased	No			100	f	23.6667	0.16	0.3368421		12/07/10	

Location

MAT050

121921

122245

Loc Qty

23.6667

11.6667

12

Loc Code

0.3368421

Dart Aerospace Ltd

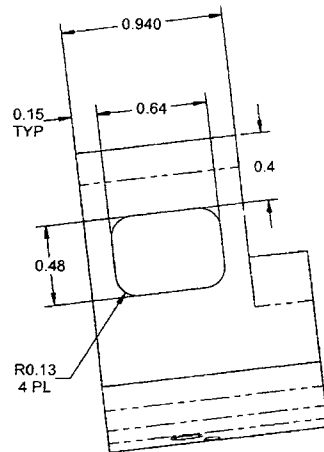
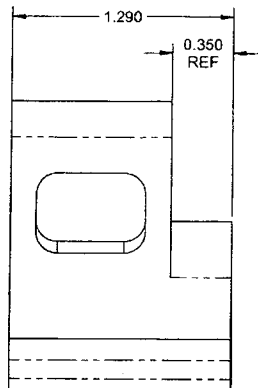
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

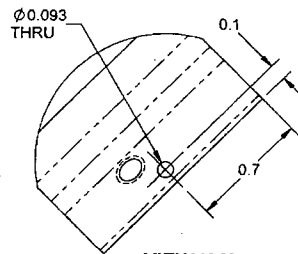
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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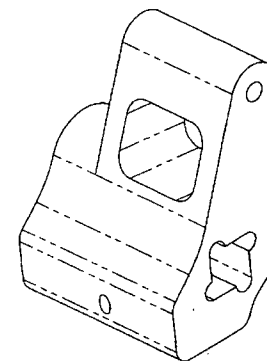
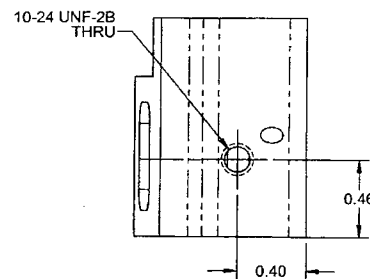
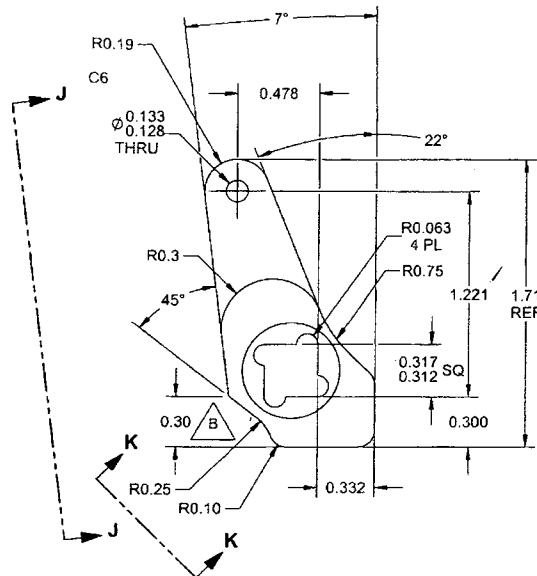
NOTE: Date & initial all entries



VIEW J-J C4



VIEW K-K C4






86616

RELEASED
2012-06-13

NOTES:

- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.14 lbs
- 8) PROFILE PER DWG FILE "D4522-11-RevB.STP"

D4522-11 HANDLE SHAFT ARM

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	D.V.	DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 14 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 86618
Description: HANDLE SHAFT ARM		Part Number: D4522-11
Inspection Dwg: D4522 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.290	±.030	1.287	—		Vern M-L	
.350	±.010	.347	—		"	
.940	±.010	.940	—		"	
.64	±.030	.640	—		"	
.15	±.030	.150	—		"	
.48	±.030	.475	—		"	
.40	±.000	.400	—		"	
R.13	±.030	R.125	—		R-G	
.478	±.010	.476	—		Vern M-L	
.332	±.000	.331	—		"	
1.221	±.010	1.222	—			
1.71	±.030	1.710	—		"	
.300	±.010	.297	—		"	
.312	±.005	.314	—		"	
Ø.128	±.005	Ø.128	—		"	
.46	±.030	.452	—		"	
.40	±.030	.400	—		"	
10-24UNF	N/A	—	—		"	
.1	±.100	.100	—		"	
.7	±.000	.689	—		"	
Ø.093	±.001	Ø.094	—		"	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 12/07/13	Date: 12.7.14	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15